

Date: Monday, 06/10/2008 1:21:08 PM
 User: Julie Lecocq

Process Sheet

| | | | |
|-----------------------|---|------------------|------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : RIGHT ARM WELDMENT |
| Job Number | : 42477 | | |
| Estimate Number | : 12104 | | |
| P.O. Number | : | Part Number | : D3354043 |
| This Issue | : 06/10/2008 S.O. No. : | Drawing Number | : D3354 REV C |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : / / Type : LARGE FAB ASSY | Drawing Revision | : C |
| Previous Run | : 36639 | Material | : |
| Written By | : | Due Date | : 24/10/2008 Qty: 6 Um: Each |
| Checked & Approved By | : <u>JUL 08.10.06</u> | | |
| Comment | : est rev A 06.01.25 new issuye EC est rev B 07.05.14 rev B dwg Ec | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|--------|-------------|
| 1.0 | D33543 | Wheel Shaft |
|-----|--------|-------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)
 pick:

| | | | |
|-----|-------------|-------------|----------|
| qty | part number | description | batch |
| 1 | D3354-3 | shaft | B36232 * |

Plc 08.10.21

| | | |
|-----|--------|-----------------|
| 2.0 | D33545 | Right Arm Plate |
|-----|--------|-----------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)
 pick:

| | | | |
|-----|-------------|-------------|-----------------------|
| qty | part number | description | batch |
| 1 | D3354-5 | right arm | B34634 → 4 B42496 → 2 |

Plc 08.10.21

| | | |
|-----|-------------|------------------------------|
| 3.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per dwg D3354

2-Grind welds flush as per dwg D3354

Plc 08.10.21

| | | |
|-----|-----|---------------------------|
| 4.0 | QC9 | VISUAL WELDING INSPECTION |
|-----|-----|---------------------------|



Comment: VISUAL WELDING INSPECTION

BE 08-10-21

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 06/10/2008 1:21:09 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIGHT ARM WELDMENT

Job Number: 42477

Part Number: D3354043

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/10/21 (x6)

6.0

POWDER COATING

POWDER COATING



M18052



Comment: POWDER COATING

1-Mask areas indicated on dwg D3354

2-Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME:

8:30am

OVEN TEMPERATURE:

320°F

FINISH TIME:

9:00am

JP 08-10-23 (x6)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8/10/23

(x6) SP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 188

8/10/23

SP
6K

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/31 (x6)

Job Completion



MF 08-10-30

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

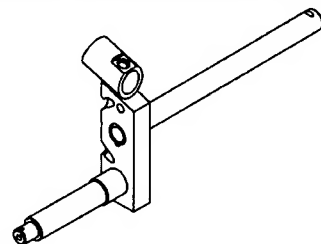
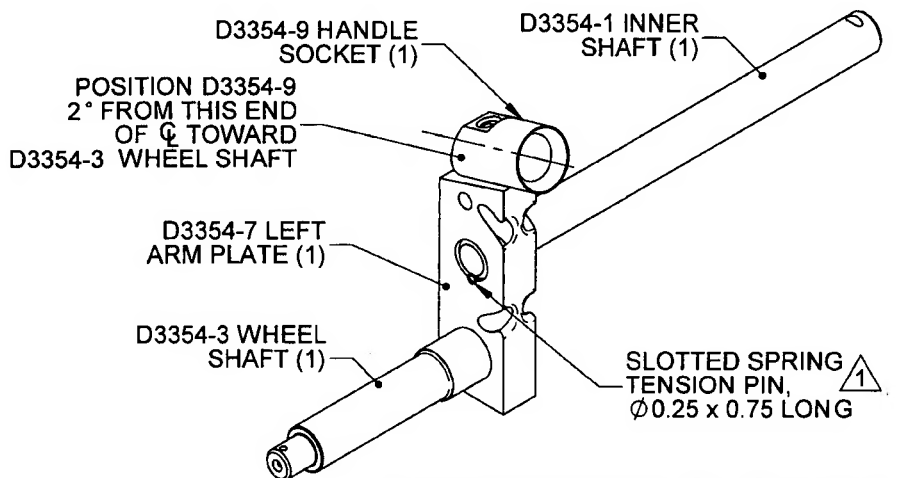
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries



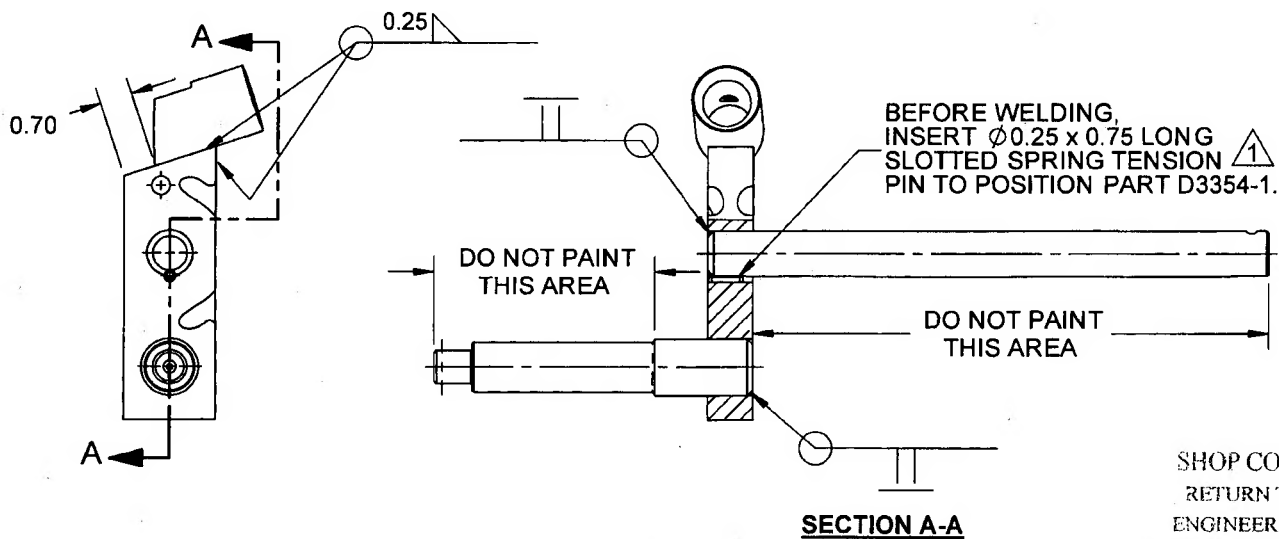
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07/12/07

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|-------------------------|-----------------------|---|------------------------|
| CHECKED <i>LB</i> | APPROVED <i>MP</i> | DRAWING NO. LEFT ARM WELDMENT | REV. C SHEET 1 OF 7 |
| DATE 07.12.06 | | TITLE D3354 | SCALE 1:4 |
| REV | DATE | DESCRIPTION | |
| A | 04.12.13 | NEW ISSUE | |
| B | 07.02.02 | REVISED DIMENSIONS | |
| C | 07.12.06 | CHANGE TOLERANCE ON D3354-7 LEFT ARM PLATE HOLE FOR D3354-3 WHEEL SHAFT | |



**D3354-042 MIRROR
ARM WELDMENT**

D3354-041 LEFT ARM WELDMENT



NOTES:

- 1) POSSIBLE SUPPLIER: SPAENAU, P/N TP-134
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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NO. *42477*

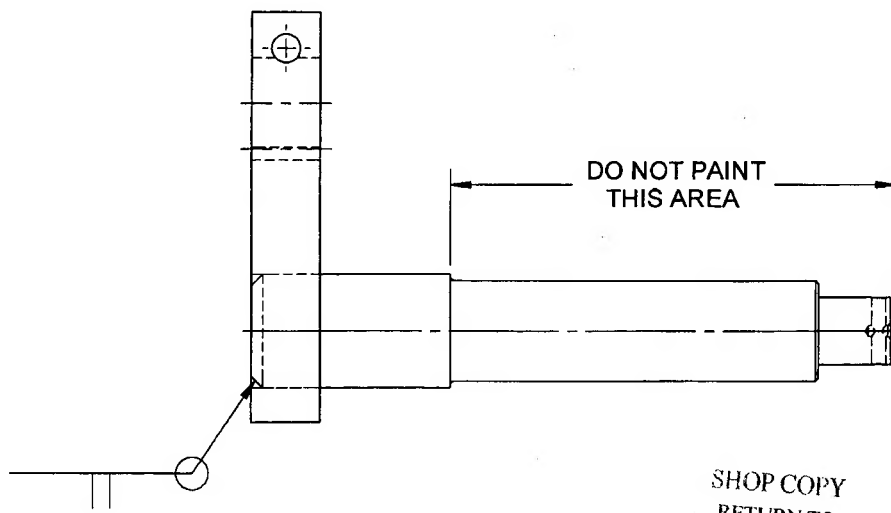
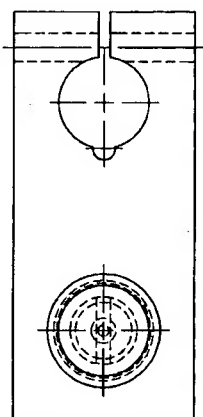
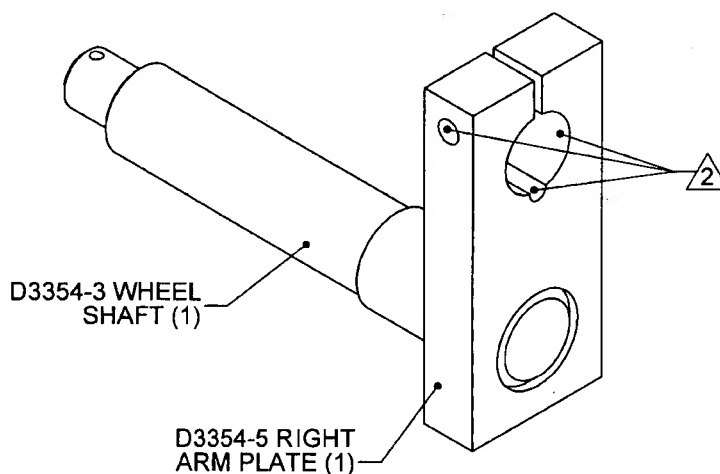
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| DATE 07.12.06 | | TITLE LEFT ARM WELDMENT | SCALE 1:2 |

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01/12/07 *WJ*



D3354-043 RIGHT ARM WELDMENT

NOTES:

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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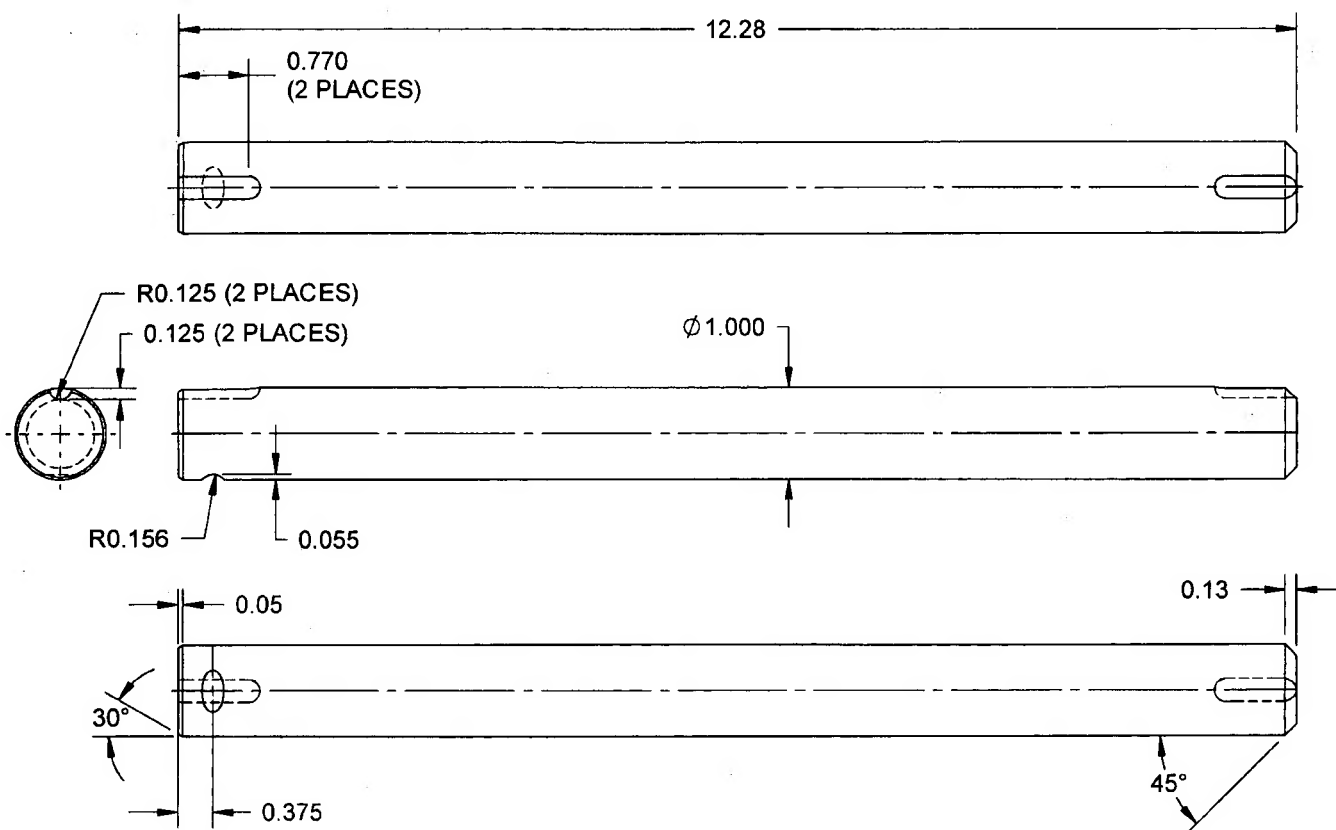
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| DATE 07.12.06 | | TITLE LEFT ARM WELDMENT | SCALE 1:2 |

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D3354-1 INNER SHAFT

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NOTES:

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, ϕ 1.250 (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

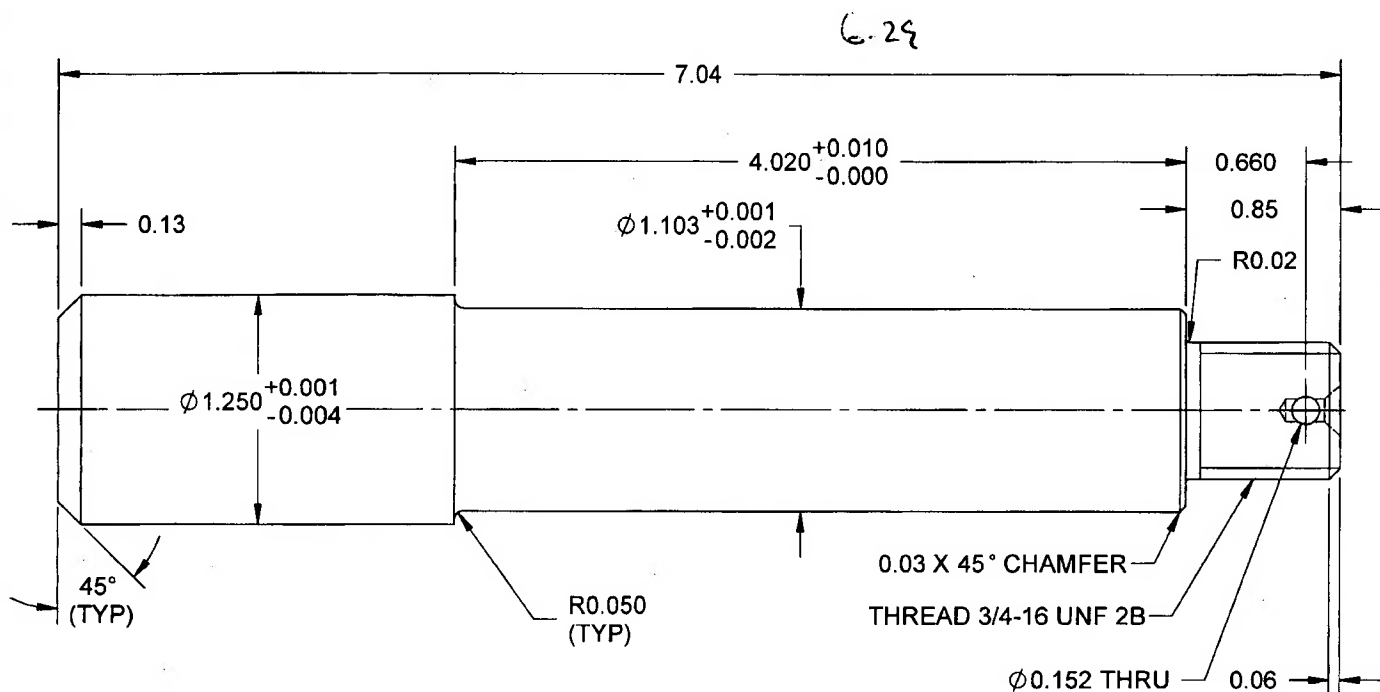
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| DATE 07.12.06 | TITLE LEFT ARM WELDMENT | | SCALE 1:1 |

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07.12.07 *MP*



D3354-3 WHEEL SHAFT

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NOTES:

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, $\phi 1.250$ (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

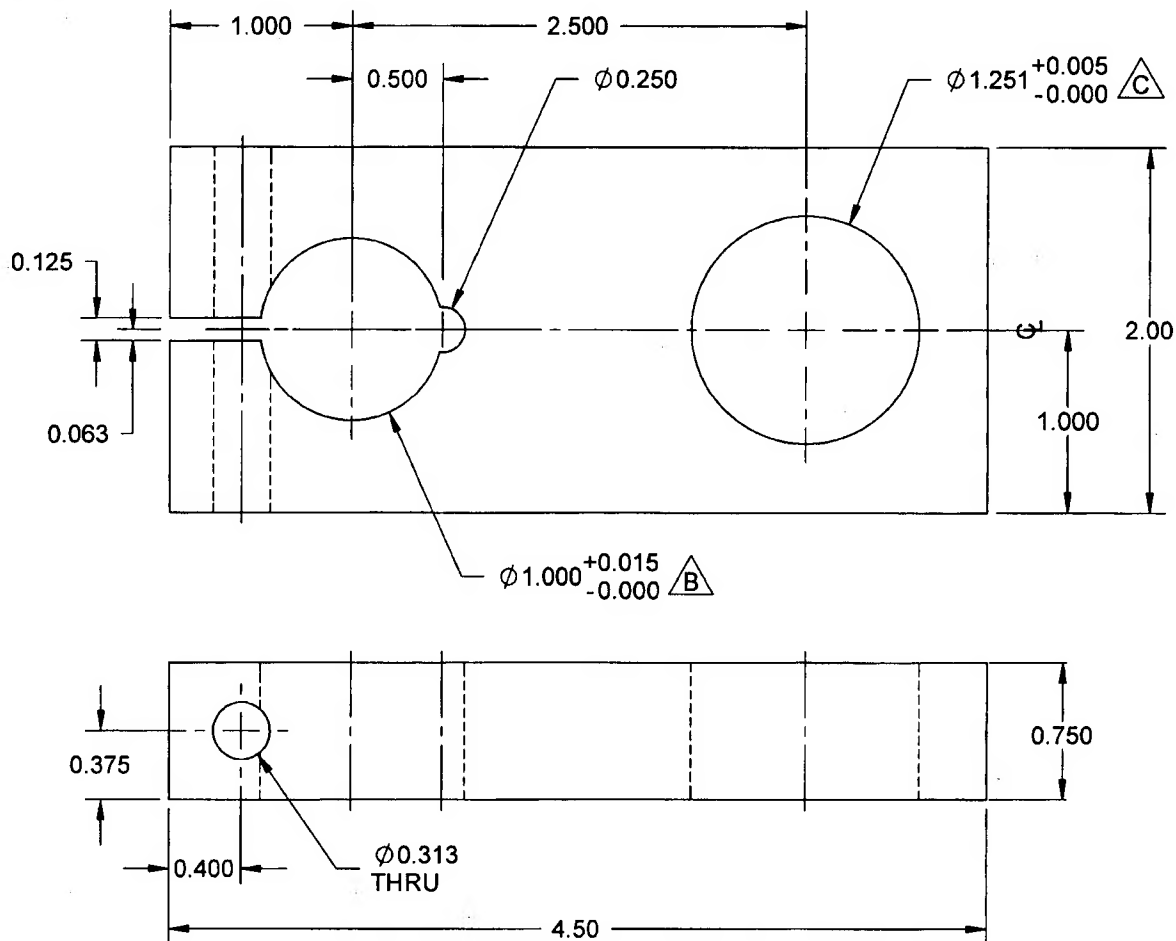
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| DATE 07.12.06 | | TITLE LEFT ARM WELDMENT | SCALE 1:1 |

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D3354-5 RIGHT ARM PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

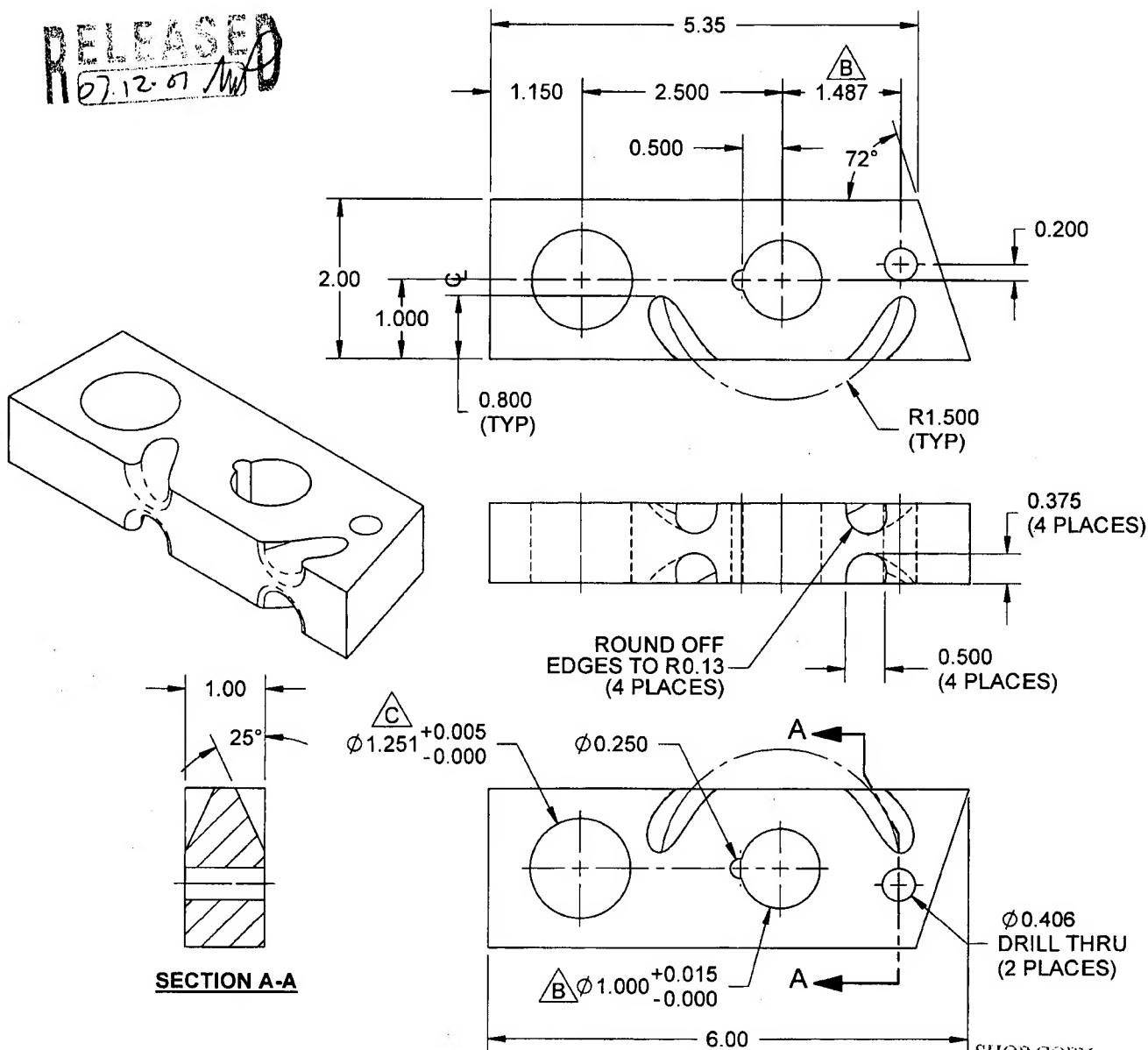
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| CHECKED <i>LA</i> | APPROVED <i>MM</i> | DRAWING NO. D3354 | REV. C SHEET 6 OF 7 |
| DATE 07.12.06 | TITLE LEFT ARM WELDMENT | | SCALE 1:2 |

RELEASED
07.12.07 *MM***D3354-7 LEFT ARM PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.00 THICK MILD NO. 42477 STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

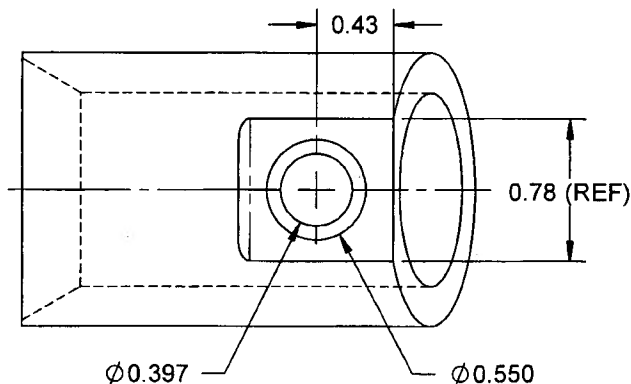
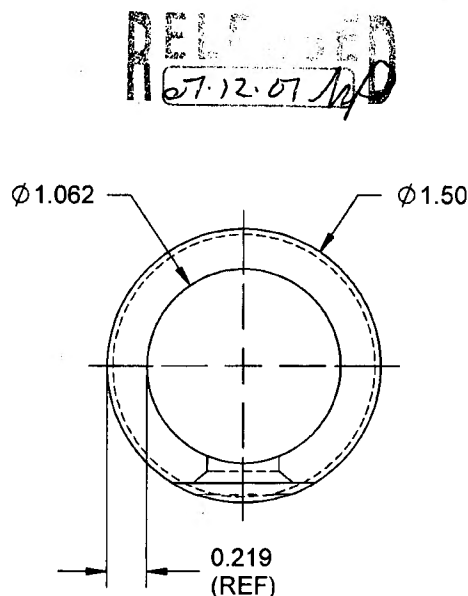
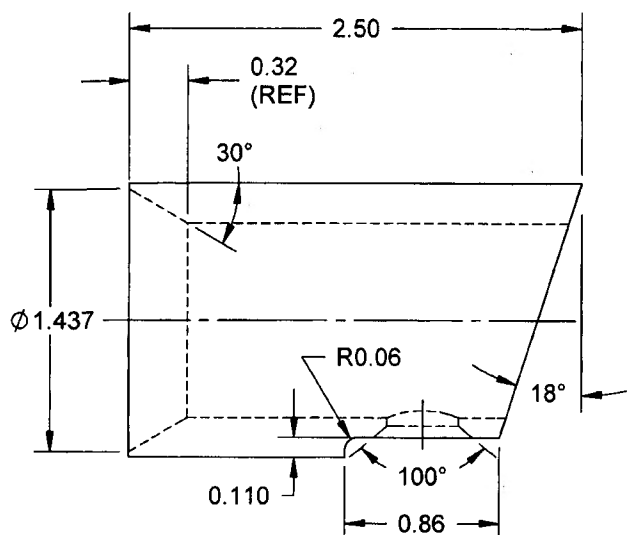
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| DATE 07.12.06 | | TITLE LEFT ARM WELDMENT | SCALE 1:1 |



D3354-9 HANDLE SOCKET

NOTES:

- 1) MATERIAL: AISI 1010-1025 SEAM LESS ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, (REF. DART SPEC. M1020TR1.250W.219)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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